

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023230**Date Inspected:** 02-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

This QA Inspector had been requested to assist Structural Material Representative (SMR) Jason Lee obtain the actual root gap and off set measurement at the Electro Slag Welding (ESW) joints on the tower in the field. This QA Inspector and/or SMR Jason Lee accessed various locations in the 3-13 meter tower sections to obtain the root gap and off set measurements. This QA Inspector and SMR Jason Lee decided to use the weld joint numbers provided by QC personnel to track the measurement of the 20 weld joints (weld # 9 thru # 28). This QA Inspector and/or SMR used a stand 15-30 mm taper gauge to measure the root gaps and a Cambridge gauge to measure the offset.

Measurements were taken at the following elevations: 3-meter, 5-meter, 9-meter, 11-meter and 13-meter. By the end of the shift this measurements had been taken at all areas accessible, approximately 196 of the proposed 200 measurement locations had been accessed and measurements taken; see photo below of weld joint #16 (East Shear plate, South corner) from the 13 meter elevation.

**Summary of Conversations:**

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted below there were no notable conversations.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hager,Craig
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell,Bill
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QA Reviewer
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